

Work Order ID 87754

July-11-12 11:26:31 AM

87754

Page 1

Item ID: D3916-041

Revision ID:

Item Name: Rib Assembly

Start Date: 11/07/2012 Start Qty: 6.00

Required Date: 17/07/2012 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLS

QC:

Date: 12/07/11

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3916

A

100

0.00

100

Large Fab

Large Fab

Memo

0.00

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D3916

4- Drill and chamfer holes as per dwg D3916-1 using DT9605

SAD 12-07-26 (6)

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Quality Control

Memo

0.00

6x

12-07-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87754

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Item ID: D3916-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly

Start Date: 11/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

107

Weld per dwg. A/R S.S. rod Batch: M114509

0.00

107

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D3916
2- grind welds flush

②

PD 12-08-03

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

2x

12.8.3

DAS
24
2-8

120

QC10- Inspect visual per QS1004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

2x

12.8.3

DAS
24
2-8

W/O:		WORK ORDER CHANGES					
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25 AS								
25 AS								

NOTE: Date & initial all entries

Work Order ID 87754

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Item ID: D3916-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib Assembly

Start Date: 11/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: WA

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

2

612.5.3

12/8/13

mf 12-08-07

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July-11-12 11:26:35 AM

Page 1

Work Order ID: 87754

87754

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 11/07/2012

Required Date: 17/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1		Manufactured	No			100	Each	170.0000	7	42			
D3759-1									**				
Bushing													

Location

Loc Qty

Loc Code

WA

163

79213

1

83464

162

WA005

7

66489

1

82785

6

M304TS0.750W.049

Purchased

No

100

f

152.6297

4.166

26.31158

M304TS0 750W 049

**

304 SQ Tube .75x.75x.049W

Location

Loc Qty

Loc Code

MAT017

31.716337

121898

31.716337

MAT018

119.8508959

119147

2

119643

3.30639585

121439

16.8353

122201

97.7092

WA034

1.0625

121087

1.0625

14

PD 12-08-03

SAD 12-07-20

26.3116

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

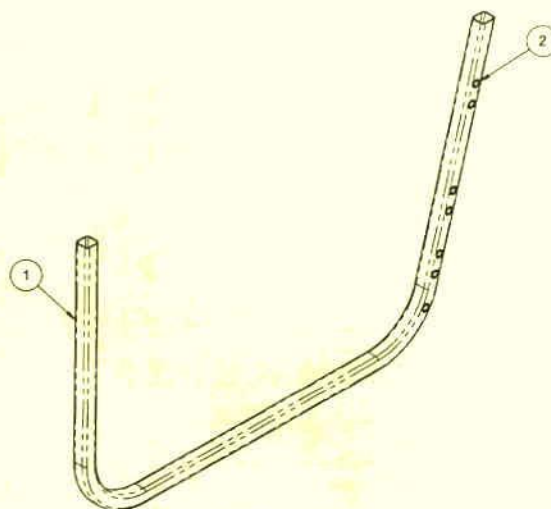
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

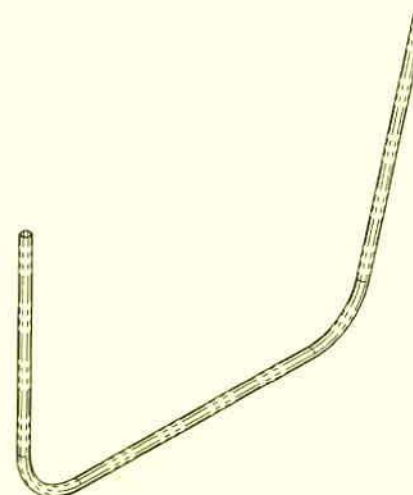
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ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 87754 ML5
12/07/11

OL 10.12.21
~~UNDER REVIEW~~
10.12.21
ADDITION OF HOLE + BUSHINGS
ON D3916-041-1 RIBS.
RELEASED
2010-03-12
JNP

REV	NEW ISSUE	DESCRIPTION	JPH	10.03.04
DESIGN	AJS		BY	DATE
DRAWN	JPH			
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	10.03.04			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3916** REV. A
SHEET 1 OF 4
TITLE **RIB ASSY, 350 BASKET** SCALE NTS

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

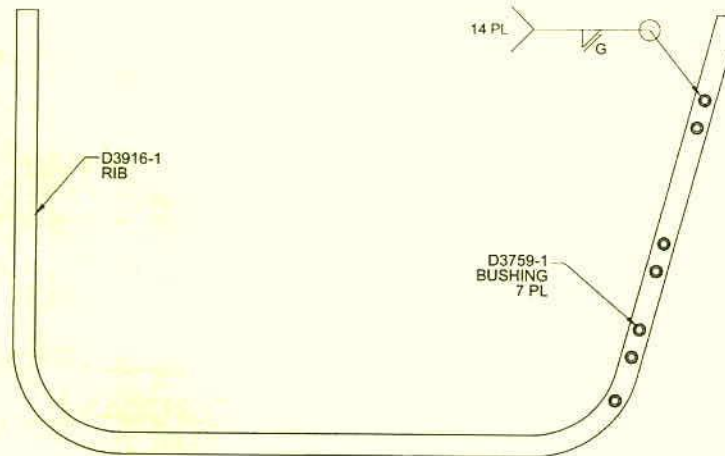
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

87754



D3916-041 RIB ASSY

RELEASED
2010-03-12
MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT -041: 1.84 lbs
- 8) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 2 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE LOANED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

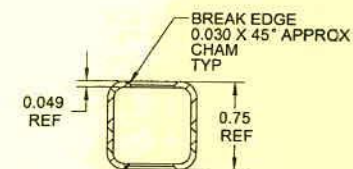
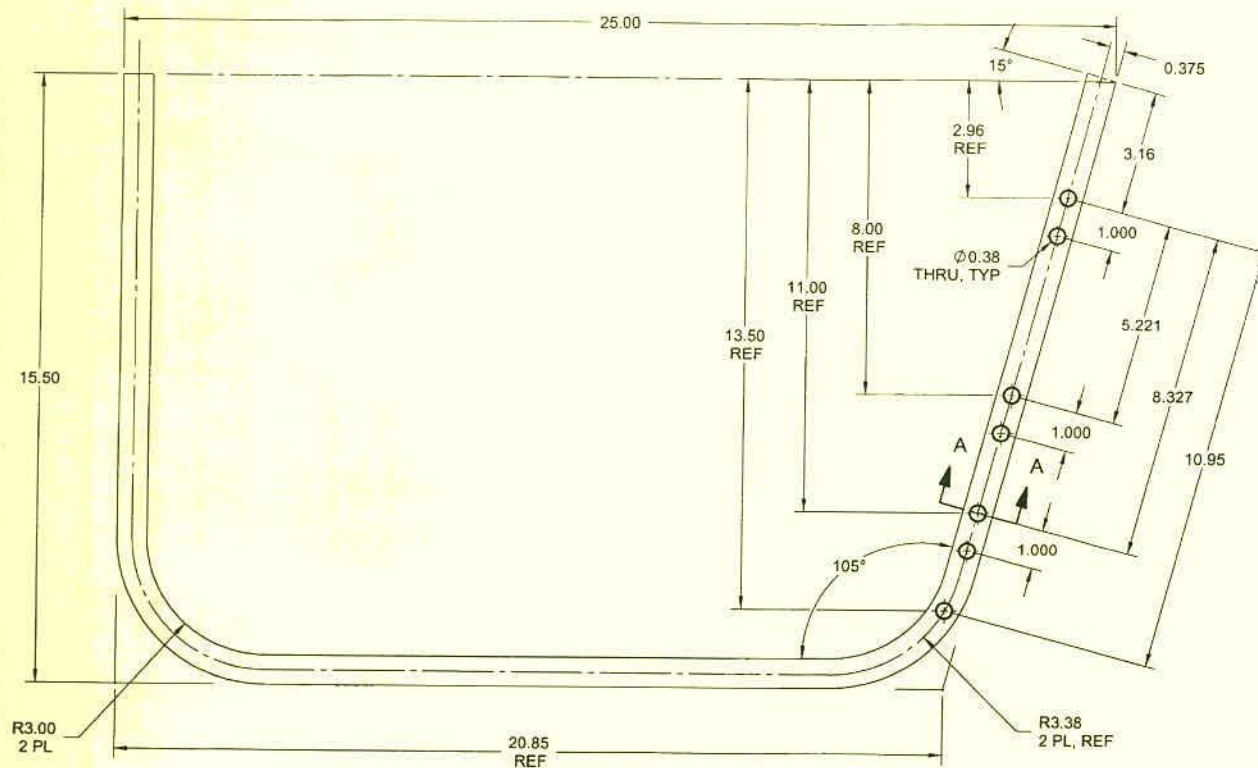
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A

9 D3916-1 RIB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

RELEASED
2010-03-12

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MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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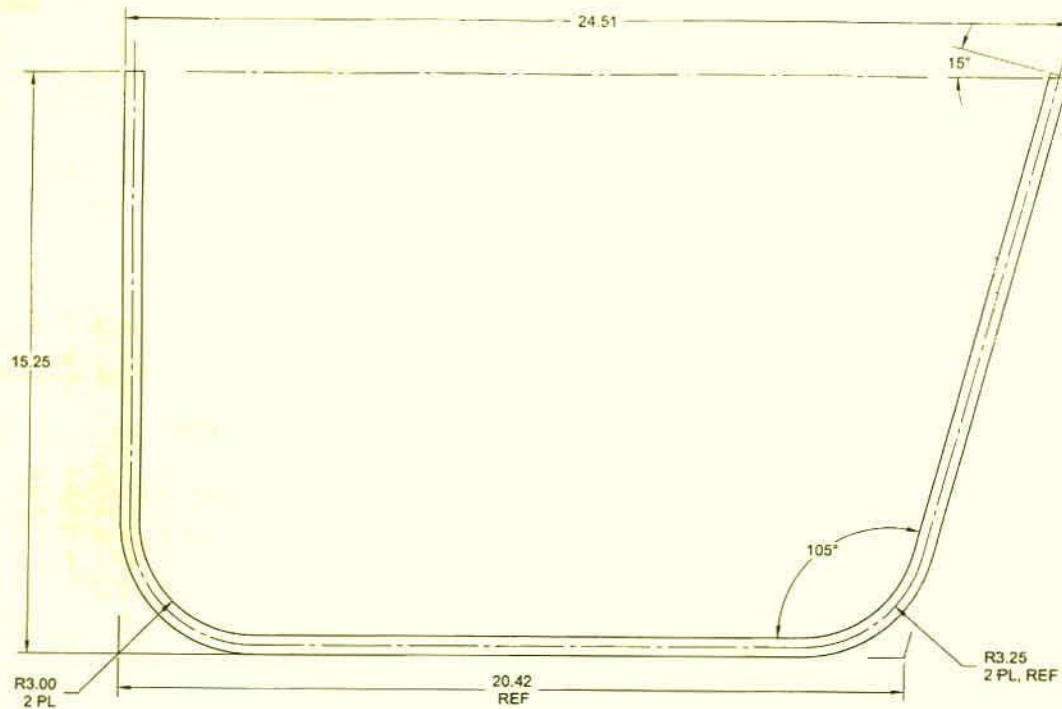
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section: C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

87754



9 D3916-5 LIGHT RIB

RELEASED
2010-03-12
NA

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A
MFG. APPR.	<i>[Signature]</i>	TITLE RIB ASSY, 350 BASKET	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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